Page 1

Work Order ID 50144 July 8, 2009 1:43:48 PM Item ID: D3065-3 Accept Setup Start В **Revision ID:** Stop Item Name: Step Spacer **Start Qty: 80.00 Start Date:** 07/08/2009 **Cust Item ID: Required Date: 07/15/2009** Req'd Qty: 80.00 **Customer:** Reference: Start Run Process Plan: MF Date: 09-07-08Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Draw Draw Plan Reject Set Up/ Accept Reject Work Center ID Description Qty Number Rev. Code Oty Number Stamp **Run Hours** Draw Nbr **Revision Nbr** D3065 Rev B 100 0.00 FLOW WATER JET Waterjet 0.00 Memo _[]Prog Rev: R FLOW CNC Waterjet 1-Cut as per Dwg D \quad Dwg Rev: \(\mathbb{B}\) □2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00

QC

Memo



Quality Control

Work Order ID 50144

Page 2

July 8, 2009 1:43:48 PM

Item ID:

D3065-3

В

Revision ID:

Step Spacer Item Name:

Start Date:

07/08/2009

Start Qty: 80.00

Req'd Qty: 80.00

Accept



Setup Start

Stop



Required Date: 07/15/2009

QC:



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Draw

Rev.

Start Run

Reject

Qty

Accept

Qty

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr Stack

Set Up/ **Run Hours**

0.00

0.00

140

Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3065

0.00

0.00



Plan

Code

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

В

Page 3

Item ID:

D3065-3

Accept

Setup Start

Stop



Revision ID:

Step Spacer Item Name:

Required Date: 07/15/2009

July 8, 2009 1:43:48 PM

07/08/2009

Start Qty: 80.00

Req'd Qty: 80.00



Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Reject

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Draw

Rev.

Stop

Sequence ID/ **Work Center ID**

160

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Run Hours 0.00

Number

Draw

Plan Code

Accept Qty

Reject Qty

Insp. Number Stamp

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

180

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Packaging

0 0 8 9 (07 /15

В

July 8, 2009 1:43:48 PM

Required Date: 07/15/2009

Item ID:

D3065-3

Setup Start



Revision ID:

Item Name:

Step Spacer

07/08/2009 **Start Qty: 80.00**

Req'd Qty: 80.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Accept

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

190

QC

Description

Memo

Operation

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Draw Number

Plan Draw Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

Rev.

Quality Control

0.00

mr 09-07-15

July 8, 2009 1:43:47 PM

Work Order ID: 50144

Parent Item:

D3065-3RevB

Parent Item Name: Step Spacer

Comments:



Start Date: 07/08/2009

Required Date: 07/15/2009

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	77.9100	18.3411			



2024-T3 .040 sheet

Warehouse	Loc Qty	Loc Code		
Location				
Main Warehouse				
MAT	77.91			
110337	6.4			
111381	4			4
111786	67.51		M, M	09.07.10

DART AEROSPACE LTD	Work Order:	50144
Description: STEP SPACER	Part Number:	D3065-3
Inspection Dwg: D30/a5 Rev: R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$ 1.250	+0.012-0.001	1.252	\int		VerN	
\$ 0.129	+0.005-0.001		1		VWN	
6.520	+1-0.010	6.519	√		NWN	
40186	H-0.010	4.183	√		VENN	
2.093	4-0.00	2.092	1		VUN	
0.250	+1-0.010	0.248	V		vern	
1,260	11-0.010	1.259			vern	
3.260	4-0.010	3,258	1		VerN	
3.936	+1-0.010	3.936	1		verN	
1.454	4-0.010	1.450	√		VONN	
2.658	H-0.010	2.654	1	*	VWN	
3.862	+1-0.010	3.860	1		VINN	
		:				
	-					
51						

Measured by:	ml.ml	Audited by:	Prototype Approvai:	
Date:	V	Date: 05/07/13	Date: /g	

Rev	Date	Change	Revised by	Approved
A	• • •	New Issue	KJ/JLM	

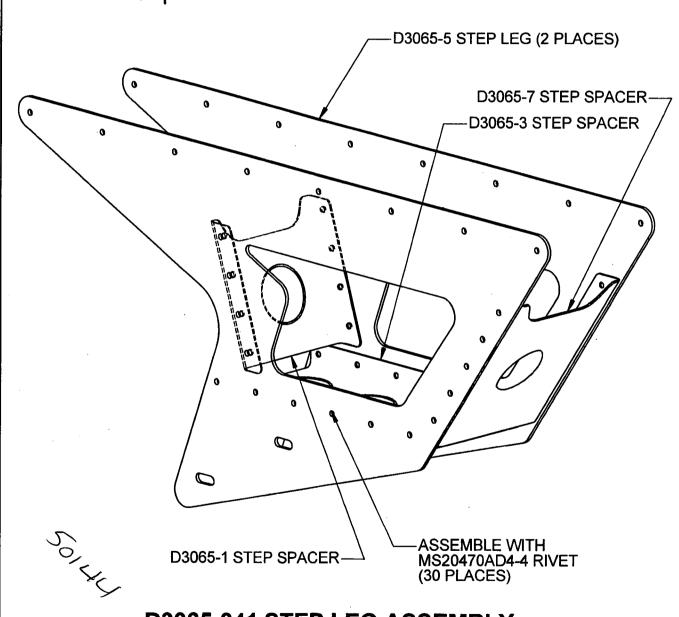




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DESIGN	4	DRAWN BY \mathcal{B}	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECK	ED	APPROVED	DRAWING NO.	REV. B
	PH		D3065	SHEET 1 OF 5
DATE	00.0)E 00	TITLE	SCALE
	00.0)5.23	STEP LEG ASSEMBLY	1:2
Α	0:	2.09.11	NEW ISSUE	
В	00	3.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS	TO D3065-5

RELEASED

de ck 20



D3065-041 STEP LEG ASSEMBLY

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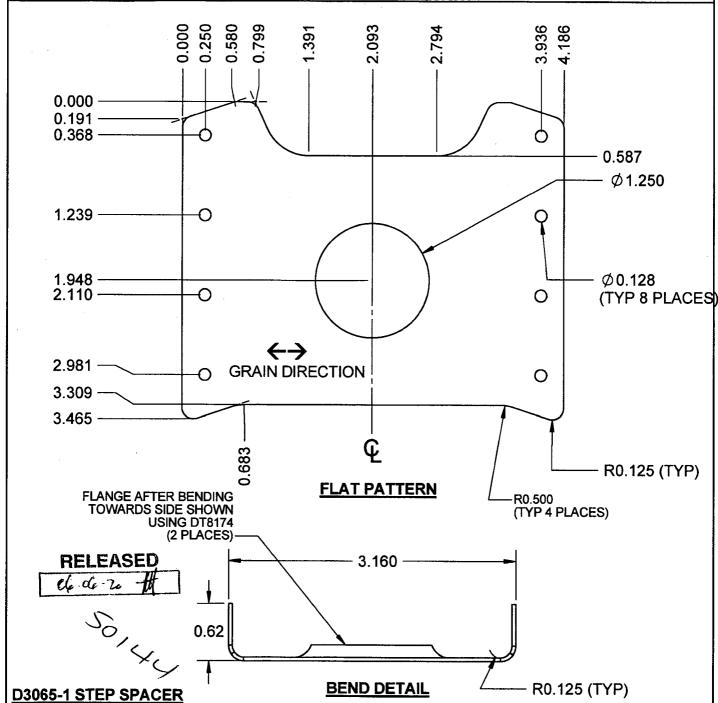
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W/O:			WC	RK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	Jory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B		cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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[.] H:ffFQRMS\Quality Assurance\approved QA\NCRWO RevE







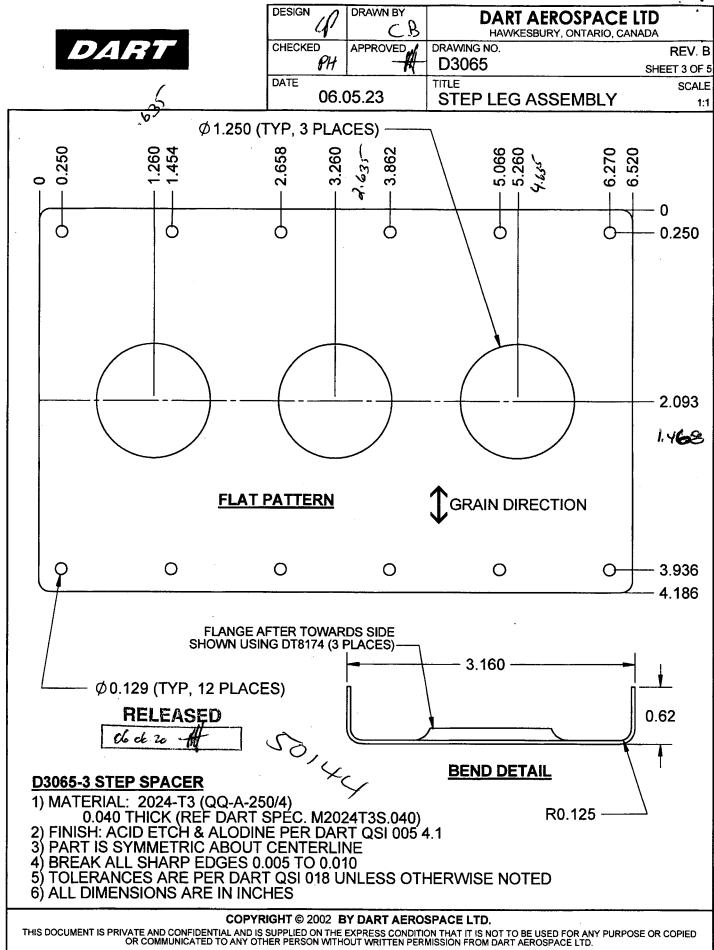
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:			W	ORK ORDER CHAN	IGES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	\ :	Date:	
	Res	solution:	Dispositio	n:	QA: I	VC Clo	sed:		Date:	
NCR:		,	WORK ORD	ER NON-CONFORM	MANCE	(NCR)				
DATE	STEP	Description of NC			ection B	Ciam 0		ation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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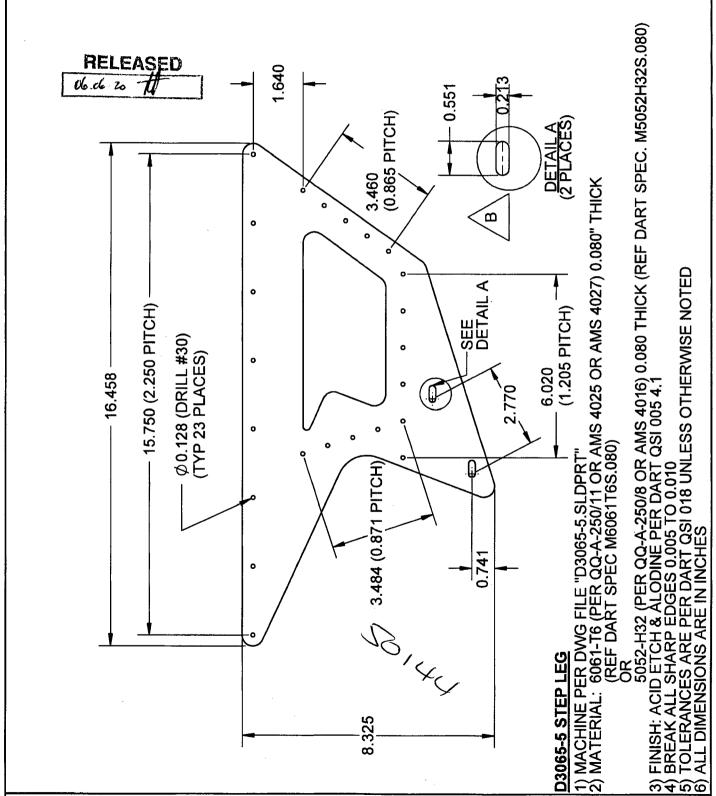
Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGES					
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Categ	gory: I	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	n: (A: N/C C	losed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCI	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	Sign -	& Sec	cation tion C	Approval Chief Eng	Approval QC Inspector
			Office Ling	Office Eng	Date				
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W/O:		WORK ORDER	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							
Part No) :	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

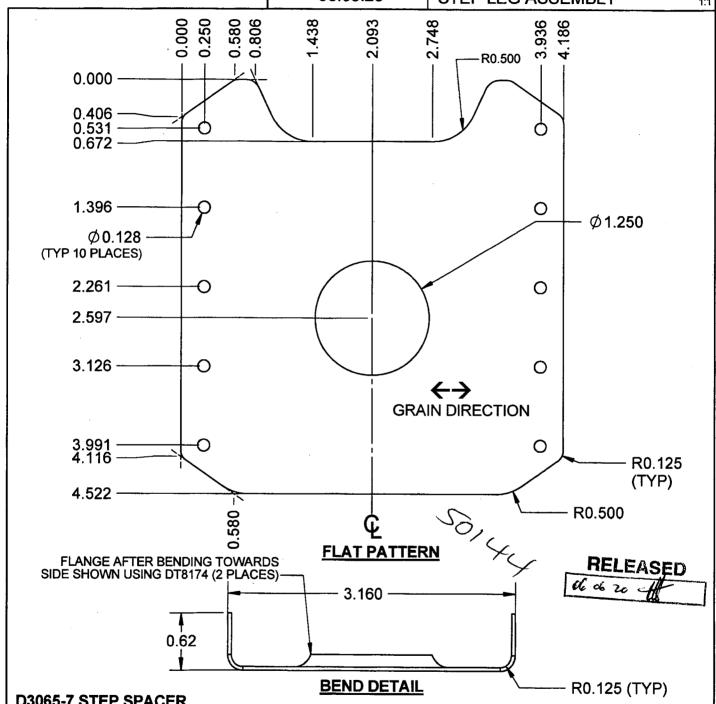
Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
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D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		70.4							
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	_ Date: _	
Resolution:		Dispositi	Disposition: C		QA: N/C Closed:				
NCR:		1	NORK ORI	DER NON-CONFORMA	NCE (NCF	₹)			
DATE	OTED	Description of NC	Corrective Action Section B			Verificatio		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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